



Dart Aerospace Ltd.
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Canada

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D3137-3

Job Sheet 190223



Part No: D3137-3

Job Qty: 20 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/15/19

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A 02.05.29 New Issue NG IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC IPP
Rev c 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	3/15/19	3/15/19	0.00	0.25	Bandsaw - 1		BT - mml 19/02/07
110	HAAS 4 Axis - B4B	20 pcs	3/15/19	3/15/19	0.00	4.68	HAAS - 1 - B4B		mml 19/02/07
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs	3/15/19	3/15/19	0.00	0.00	QC 8 - 12		x / mml 19/02/21
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		.00 0.00
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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Container No: S152166



Part: D3137-3

Job No: 190223

Serial No/Batch: S152166

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/08/19

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5019 FEB 22 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
150 QC 21 - SA 20 pcs 3/15/19 0.00 0.00				QC 21 - SA - 21	DAG 21 FEB 22 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	8-55

Part Op 100 - Bandsaw - Cut Blanks. Blank size: 1.250" x .750" x .950" long
 Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA242 & Dwg D3137
 130 - QC8- Inspect parts - second check
 140 - Identify as per dwg & Stock Location: _____
 150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINB0.750X1.250	Delrin Bar	2.0600 ft (.103 ea)	100-Bandsaw - 1	5068422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRINB0.750X1.250	2	60	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guide	0.175inches $\pm$ 0.010	0.185 0.165		
2	Guide	0.257inches + 0.005 - 0.000	0.262 0.257		
3	Guide	0.650inches $\pm$ 0.010	0.660 0.640		
4	Guide	100Degrees $\pm$ 0	100 100		
5	Guide	0.425inches $\pm$ 0.010	0.435 0.415		
6	Guide	0.550inches $\pm$ 0.010	0.560 0.540		
7	Guide	1.100inches $\pm$ 0.010	1.110 1.090		
8	Guide	0.470inches $\pm$ 0.010	0.480 0.460		
9	Guide	0.850inches $\pm$ 0.010	0.860 0.840		
10	Guide	0.143inches $\pm$ 0.010	0.153 0.133		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			